

Date: Wednesday, 2/8/2006 1:22:52 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TOP	
Job Number	: 25743		Part Number	: D32491	
Estimate Number	: 10878		Drawing Number	: D3249 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/8/2006	S.O. No.	: N/A <i>06.02.08</i>		
Prsh Rev.	: NC		Drawing Revision	: B	
First Issue	: N/A		Material	: N/A	
Previous Run	: 25723		Due Date	: 2/28/2006	
Written By	: <i>See comment below</i>		Qty:	20	Um: Each
Checked & Approved By	: <i>[Signature]</i>				
Comment	: Est. B 04.10.26 D3249-1 no longer made in-house				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O <i>535</i> Fabricate D3249-1 as per Dwg D3249 Possible supplier: Industrial Laser Material release note is required
2.0	D32491B	Top
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Top
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK
		<i>Prog/4/6</i> <i>(20)</i> <i>J. J. 04.06</i> <i>20</i>
		Comment: DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr
		<i>JAD</i> <i>06.05.08</i> <i>M.F.</i> <i>06.05.08</i> <i>(20)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/8/2006 1:22:52 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP

Job Number: 25743

Part Number: D32491

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



20
QC5-09

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m.p. 06-05-09 20

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m. 06-05-15 00

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20
QC3-17

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 28

AS
20

20

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

20
06/05/18

Job Completion



h 06/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Quotation

Date: 08-Feb-06

Company: DART AEROSPACE

To: LINDA LACELLE
From: JEFF MOSTAT

Quote No.: DA-020806-01

Part No: AS SHOWN

Quantity	PART DESCRIPTION	Cut Charge	Form Charge	Material Charge.	Part Charge.		Lot Charge
20	D3249-C1	\$22.00	\$2.00		\$24.00	ea.	\$480.00
20	D3250-C1	\$32.00	\$2.00		\$34.00	ea.	\$680.00
	material (on Dart Acct.) *4 sheets 4' x 12' 2024 T3						
4	Bare (2 weeks delivery)			\$392.00		ea.	\$1,568.00
4	Alclad (available now)			\$444.00		ea.	\$1,776.00
	Copper/Brass supplies						
	*nesting utilizes 3.5 sheets						

TOTAL CHARGE THIS QUOTATION: n/a

G.S.T.: n/a

P.S.T (IF APPLICABLE): n/a

TOTAL ORDER CHARGE: n/a

TERMS AND CONDITION.

Prices good for 10 days.

F.O.B. our plant, taxes out

Terms: net 30 days with account, COD without

LEAD TIME (WORKING DAYS):

Please complete order
information below and fax return to I.L.C.

P.O. Number:

Date:

P.S.T. No.:

Signature:

~~Not ordered~~
Haw

J
OB.CM.

25/2/06

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet. Per:

*Mark J. Vrablec*Mark J. Vrablec
Director of Manufacturing Davenport Works*Kenton P. Young*Kenton P. Young
Quality Assurance Manager

525383	306094	Invoice No.	Alcoa No.
Ship Date	B.L. No.	Customer	Item
2005-11-07	87255	42246	DS-90097-1
P.O. No./Govt Contract No.			

CG1887

C&B-WHS-SCHAUMBURG

Page 1

Ship To: COPPER & BRASS SALES, INC.
415 STATE PARKWAY
SCHAUMBURG, IL 60195

Item Description
.0630 IN TK X 48.000 IN W X 144.000 IN LN CAT D 126153 (N) A/T 2024-
T3 FLAT SHEET MILL FINISH {{ P/N 061847-0 }}. PER AMS-QQ-A-
250/4 REV A & (EXCEPT OIL &
MARKING) AMS4037 REV N & (EXCEPT MARKING)
ASTM B209 REV 04 ((MARKED)) INTERLEAVED SKID
WGT: 4500 LB QUAN TOL +/-10 %
CQR D126153 REV 28 QRR 003140 CUST REQ 05-11-
06 *** W/E 05-11-12 ***

Num	Package	Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1		306626	481111	3851	90	PC	

Notes for CQR: D126153.28

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 2.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

CQR: D126153.28 -Specification Limits -----

Temp	Dir	T3	Long Transv.	UTS	TYS	EL4D	Other	Other	Aluminum						
				KSI	KSI	PCT									
Max	Min	63.0	42.0	15											
Chemical Composition				SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum	
				Max	.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15	
Alloy 2024				Min											REMAIN

Lot: 481111 -Mechanical, Physical, Metallography, Quantometer Results -----

Temp	Dir	T3	Long Transv.	No.	UTS	TYS	EL4D	Other	Other	Aluminum
				Test	KSI	KSI	PCT			
6	Max	68.4	45.5	20.5						
Min	67.5	44.9	17.5							

Anal. No

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Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

Page 0

525383 306094
Ship Date B.L. No.
2005-11-07 87255 42246
P.O. No./Govt Contract No. Customer
CG1887 C&B-WHS-SCHAUMBURG

CG1887

C&B-WHS-SCHAUMBURG

TOTAL COPIES: 2. WITH SHIPMENT

COPPER AND BRASS SALES
22355 WEST ELEVEN MILE RD
SOUTHFIELD, MI 48034

COPPER & BRASS SALES, INC.
415 STATE PARKWAY
SCHAUMBURG, IL 60195

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Director of Manufacturing Davenport Works

Kenton P. Young

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Quality Assurance Manager

525383	306094	<u>Ship Date</u>	<u>B.L. No.</u>	<u>Invoice No.</u>	<u>Alcoa No.</u>	<u>Item</u>	Page
2005-11-07	87255			42246	DS-90097-1		2
<u>P.O. No./Govt Contract No.</u>			<u>Customer</u>				

CG1887

C&B-WHS-SCHAUMBURG

Lot: 481111 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----

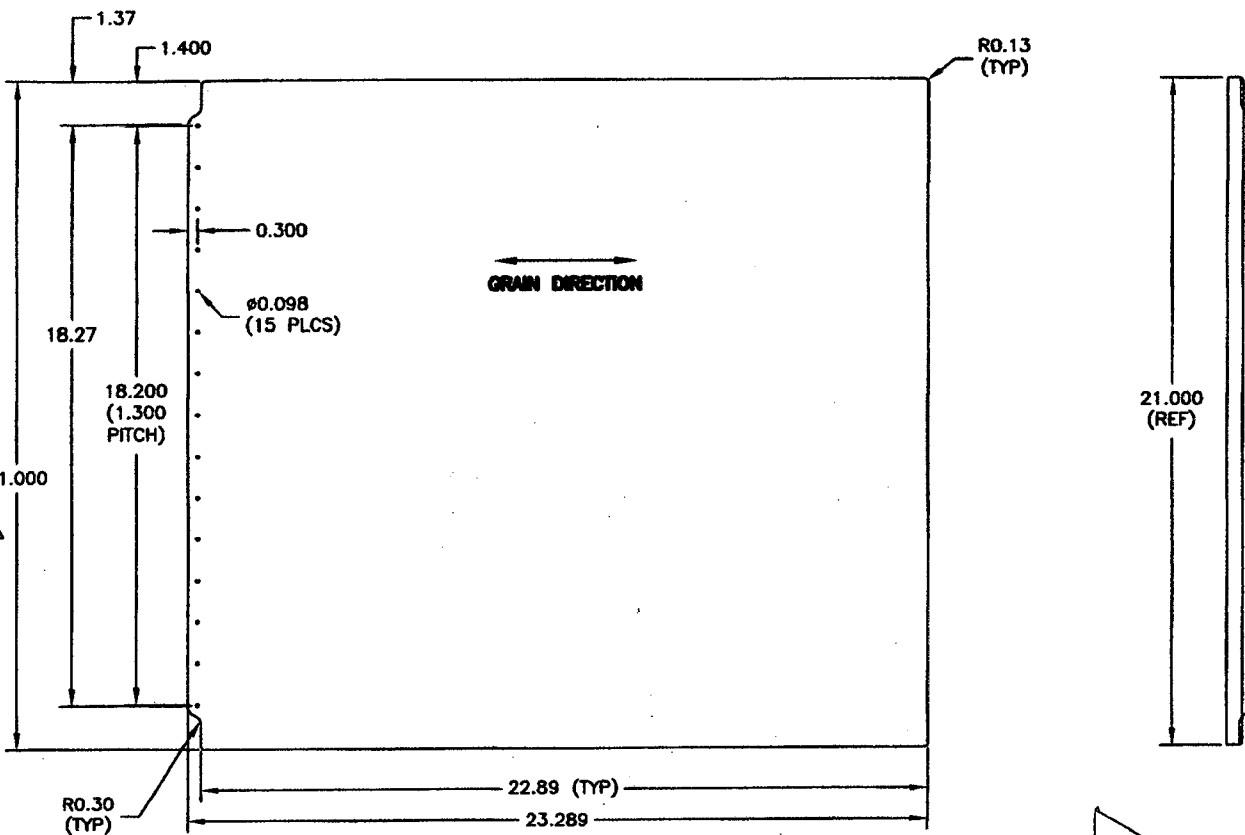
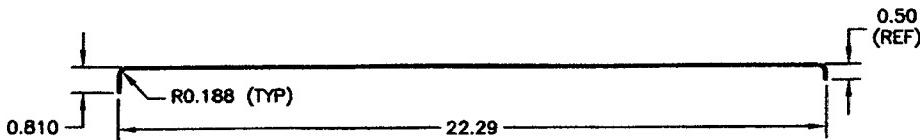
Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9214012	Actuals	.07	.14	4.6	.63	1.6	.00	.06	.03

DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3249
DATE 06.02.01	TITLE TOP (DUAL BATTERY RACK)	REV. C SHEET 1 OF 1 SCALE 1:6
A	04.04.06	NEW ISSUE
B	04.11.04	20.625 WAS 20.245
C	06.02.01	21.000 WAS 20.625, REMOVE Ø0.501 TOOLING HOLES

RELEASER
06.02.01

06.02.01

**D3249-1F FLAT PATTERN****D3249-1 BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

REFERENCE ONLY